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D3912-1
Job Sheet 183401



Part No: D3912-1

Job Qty: 10 ea

Part Name: Eyebolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-2		
100	Doosan	10 pcs	10/12/18	10/12/18	0.00	7.14	Doosan		
110	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-2		
120	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-2		
130	Packaging	10 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-2	5 to 50	
140	QC21-SA	10 Ea	10/12/18	10/12/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - TURN AS PER FOLIO FA871AND DWG Prog Rev: _____ Debur as required

9-89
DAS
21
9-89
OCT 30 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	2.8000 ft (-28 ea) 232 ea	90-Start up Operation	50/8010

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	3	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.129	
2	Eyebolt	0.700Inches ± 0.010	0.710 0.690	.701	
3	Eyebolt	0.500Inches ± 0.010	0.510 0.490	.501	
4	Eyebolt	0.900Inches ± 0.030	0.930 0.870	.900	
5	Eyebolt	0.130Inches ± 0.030	0.160 0.100	.139	
6	Eyebolt	45.0Degrees ± 0.5	45.5 44.5	45°	
7	Eyebolt	0.220Inches ± 0.030	0.250	.219	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

			0.190	
8	Eyebolt	0.750Inches ± 0.030	0.780 0.720	.752
9	Eyebolt	0.970Inches ± 0.010	0.980 0.960	.9715
10	Eyebolt	1.720Inches ± 0.030	1.750 1.690	1.722
11	Eyebolt	1.200Inches ± 0.030	1.230 1.170	1.199
12	Eyebolt	0.6250Inches ± 0.0100	0.6350 0.6150	.6245
13	Eyebolt	2.230Inches ± 0.030	2.260 2.200	2.230
14	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius R 1/8
15	Eyebolt	0.015Inches ± 0.010	0.025 0.005	Radius R .015
16	Eyebolt	0.625Inches ± 0.010	0.635 0.615	.62
17	Eyebolt	0.650Inches ± 0.010	0.660 0.640	.648
18	Eyebolt	1.100Inches ± 0.010	1.110 1.090	1.1025
19	Eyebolt	0.440Inches ± 0.030	0.470 0.410	.443
20	Eyebolt	0.130Inches ± 0.030	0.160 0.100	Radius R 1/8
21	Eyebolt	1.000Inches ± 0.030	1.030 0.970	1.01
22	Eyebolt	0.250Inches ± 0.030	0.280 0.220	.253
23	Eyebolt	0.880Inches ± 0.030	0.910 0.850	.883
24	Eyebolt	0.110Inches ± 0.030	0.140 0.080	.109
25	Eyebolt	0.719Inches + 0.010 - 0.000	0.729 0.719	.725

WORK ORDER

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rev _____ S _____ Use _____ Suspected Unapproved _____
Part No. _____	
NCR No. _____	

Date :	Step #:
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Description Work Order Deviation

Part: D3912-1
Job No: 183401
Serial No/Batch: S122032

Serial No/Batch: S122032

Revision:
Inspector:
Estimate:

Exp Date:
Instructions: Various STC's

Date: 10/27/16

Container No: S122032

**1230 Riverside Drive,
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CANADA
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Email: sales@dataero.com
www.dataerospace.com**

QC / QA Coordinator
Approval

Root Cause			FAULT CATEGORY							
Environment		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong
Design		Operator		Bending		Set-up		Folio/Program		Outside Dimensions
Doc/Data		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance
Equip/Tooling		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing
Material		Use for Testing		Cuffs		Contamination		Out of Sequence		Part Moved
Internal Transport		Poor Information		Crushing		Countersink		Off-set		Drawing
Tribal Knowledge		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish
LOA		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread
Substation		Process Improvement		Marks/Chatter		Drill Holes		Misaligned/off center		Turning Sequence
Past Expiry Date		Manufacturing Process								
Misidentified		Past Due	OTHER :							